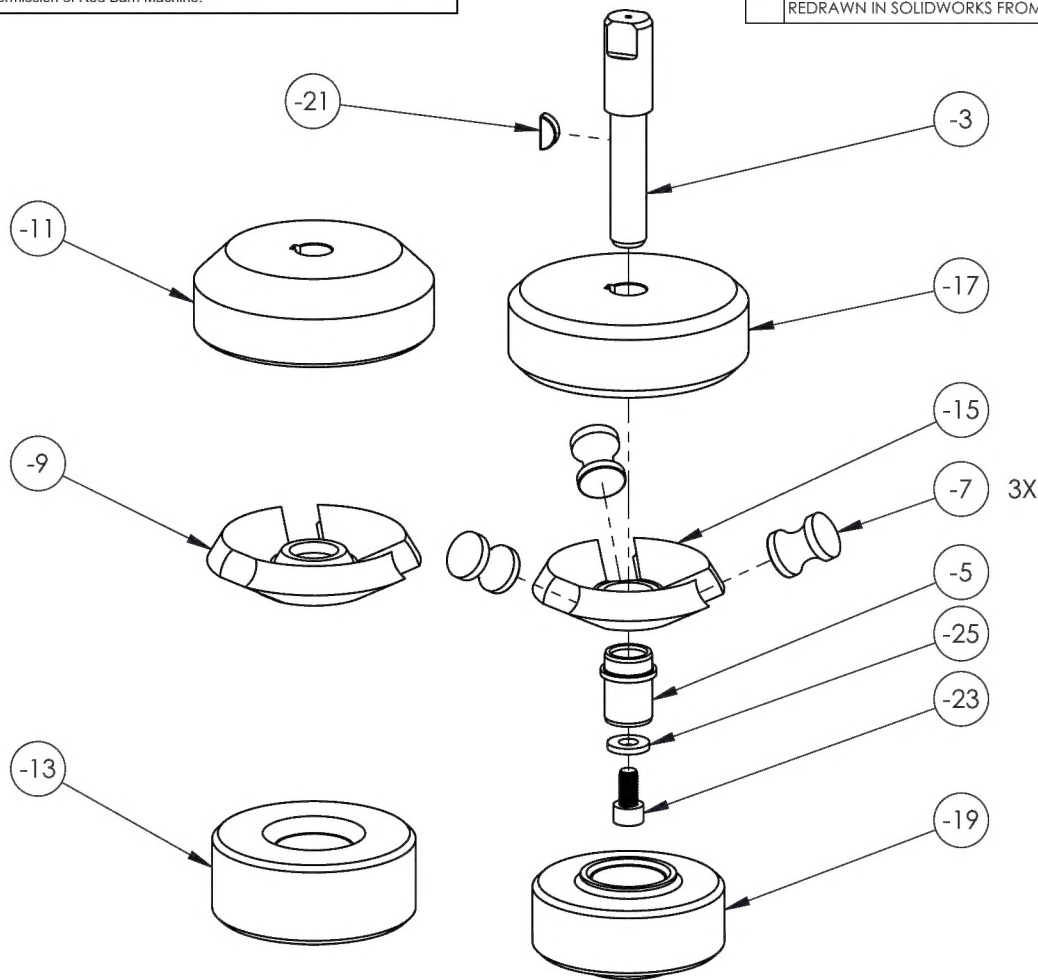


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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
	REDRAWN IN SOLIDWORKS FROM TATTERED ORIGINAL DWG.	8/30/2013	CFS



NOTE:
1. USED ON MODEL: BELL 205A1, 212, 214B, 222, 222B, 222U, 230, 407, 412, & 430.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	ARBOR	01	Ø5/8 X 2-3/4	2
			-5	1	BUSHING	ALUM. BRONZE	Ø5/8 X 1	3
			-7	3	ROLLER	01	Ø5/8 X 3/4	4
			-9	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	5
			-11	1	HOUSING	01	Ø2-5/8 X 1-1/4	6
			-13	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	7
			-15	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	8
			-17	1	HOUSING	01	Ø2-5/8 X 1	9
			-19	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	10
		B/O	-21	1	WOODRUFF KEY	STEEL	#213 WOODRUFF KEY MCMASTER-CARR #98525A075	1
		B/O	-23	1	SOCKET HEAD CAP SCREW	S.S.	#10-32 X 3/8 MCMASTER-CARR #92200A340	1
		B/O	-25	1	FLAT WASHER	STEEL	Ø.438 X .063 AIRCRAFT SPRUCE #AN960-10	1

RED BARN MACHINE

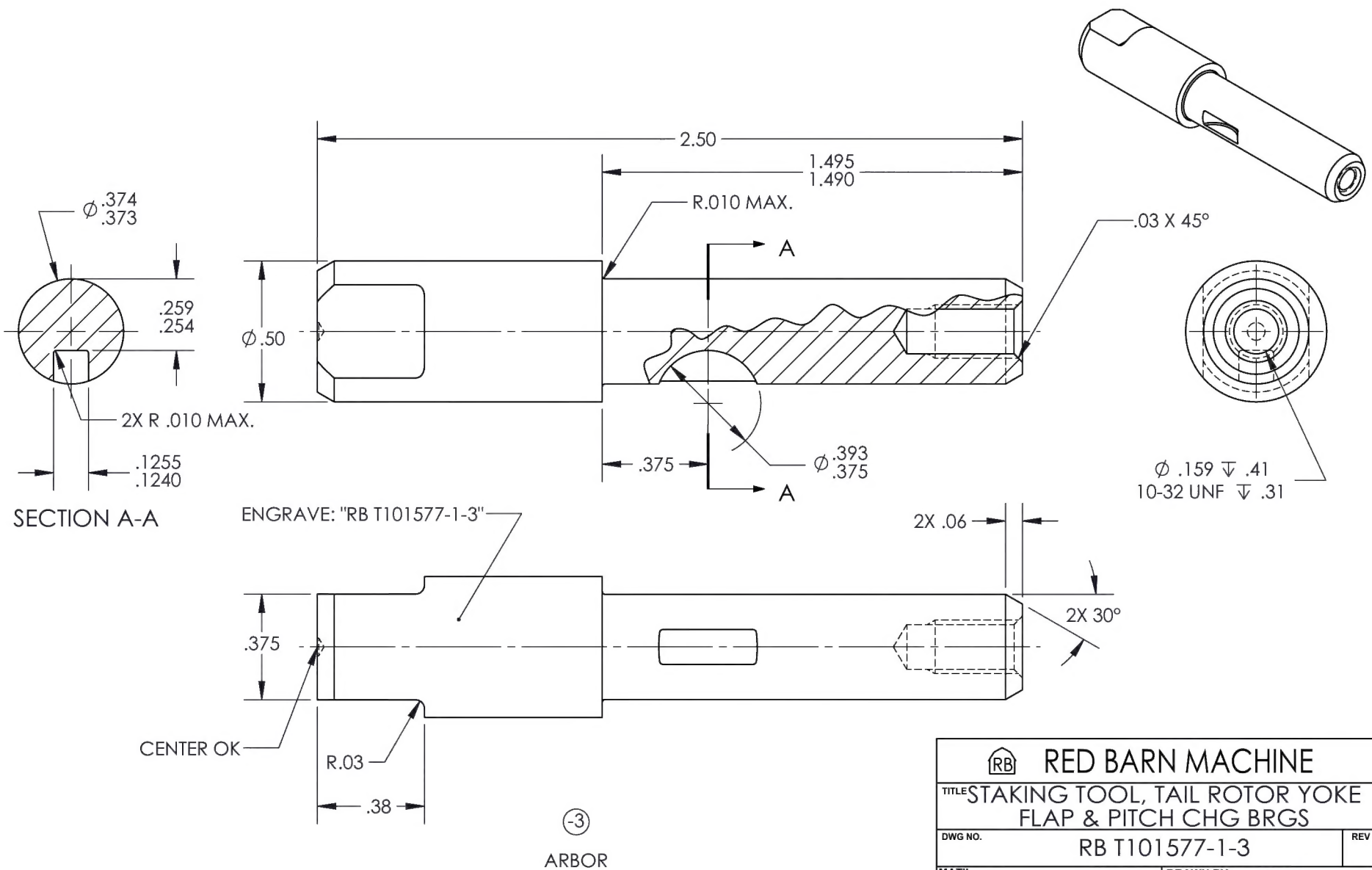
**STAKING TOOL, TAIL ROTOR YOKE
FLAP & PITCH CHG BRGS**

DWG NO. **RB T101577-1** REV

MAT'L	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SEE NOTE
SCALE 1:2	DATE 8/26/2013
	SHEET 1 OF 10

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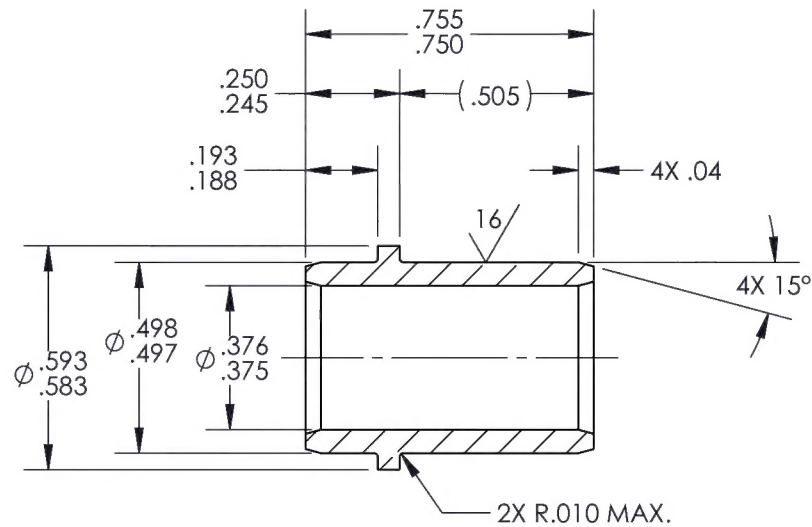
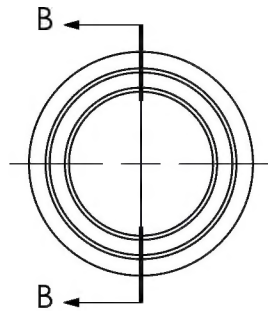
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



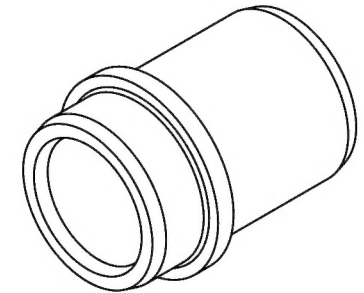
RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-3	
MAT'L 01	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT RC 58-62
.XX ± .03	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 8/26/2013
SHEET 2 OF 10	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



SECTION B-B



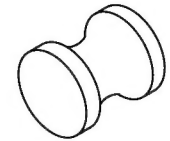
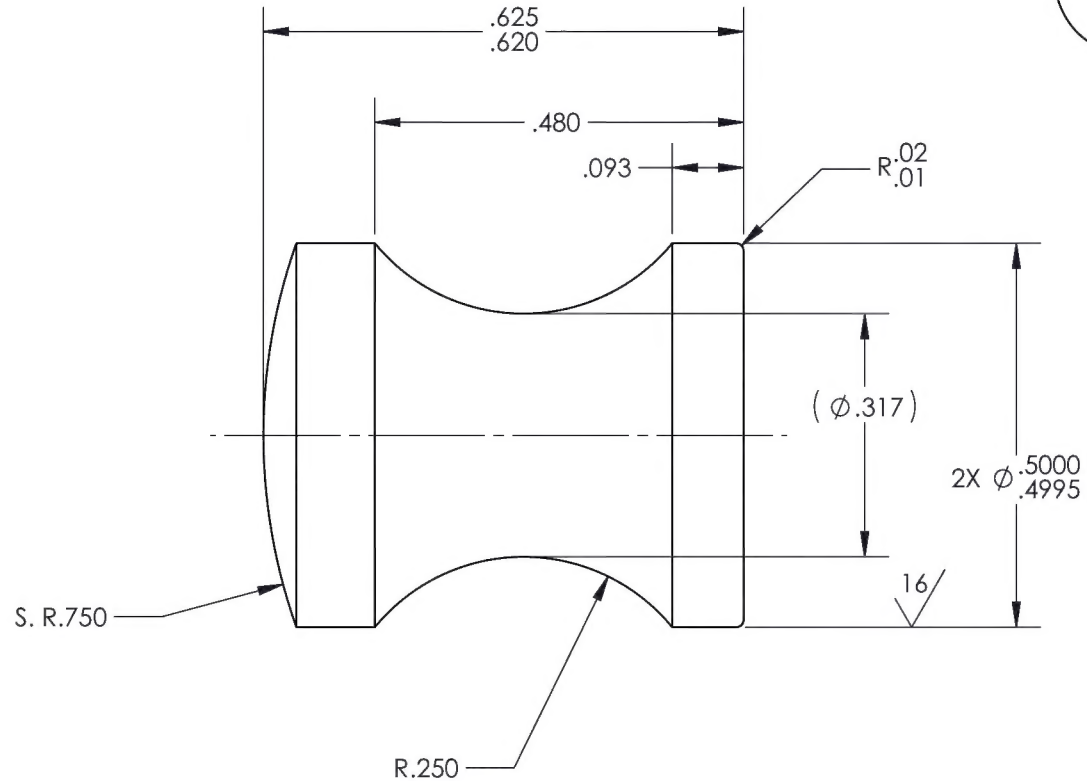
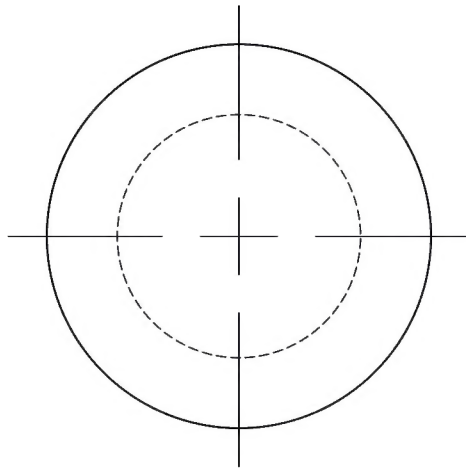
(-5)

BUSHING

RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-5	REV
MAT'L ALUM. BRONZE	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 8/26/2013
SHEET 3 OF 10	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



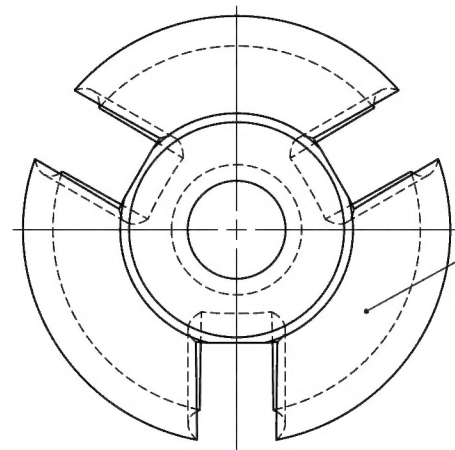
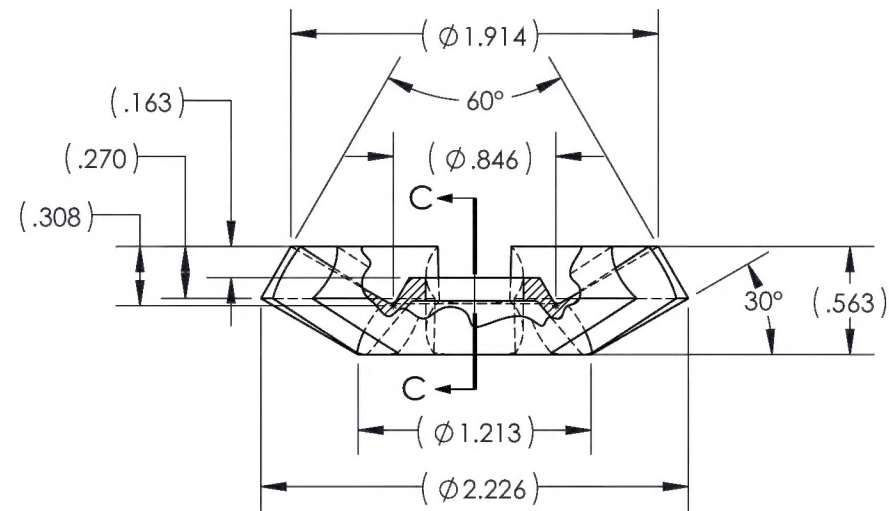
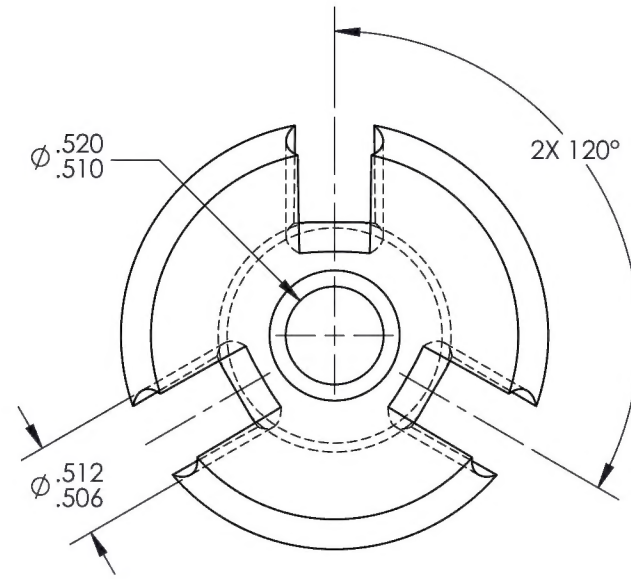
(-7)

ROLLER

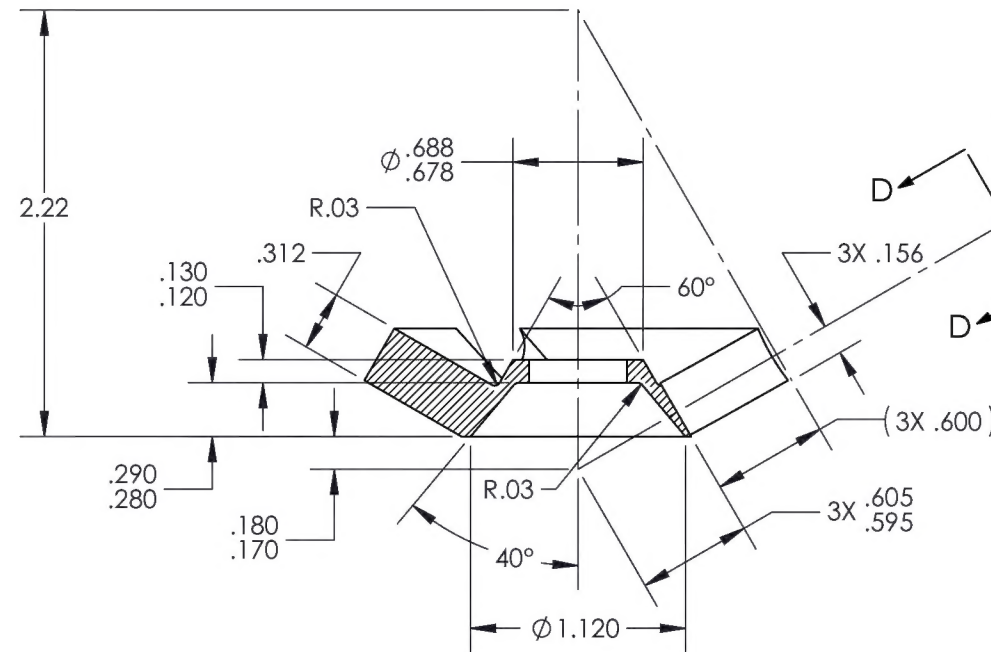
RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-7	REV
MAT'L 01	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/32 .XX ± .03 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT RC 58-62 FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 8/26/2013
SHEET 4 OF 10	

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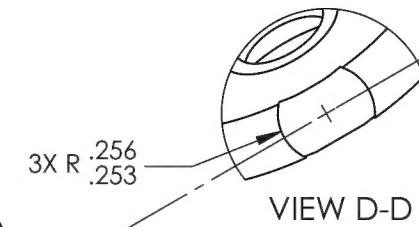
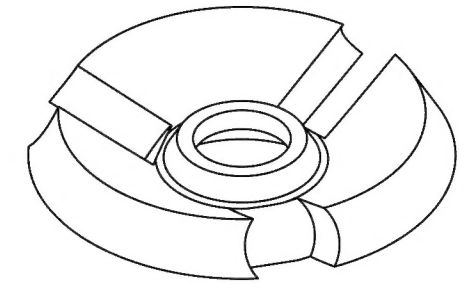
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



ENGRAVE: "RB T101577-1-9"



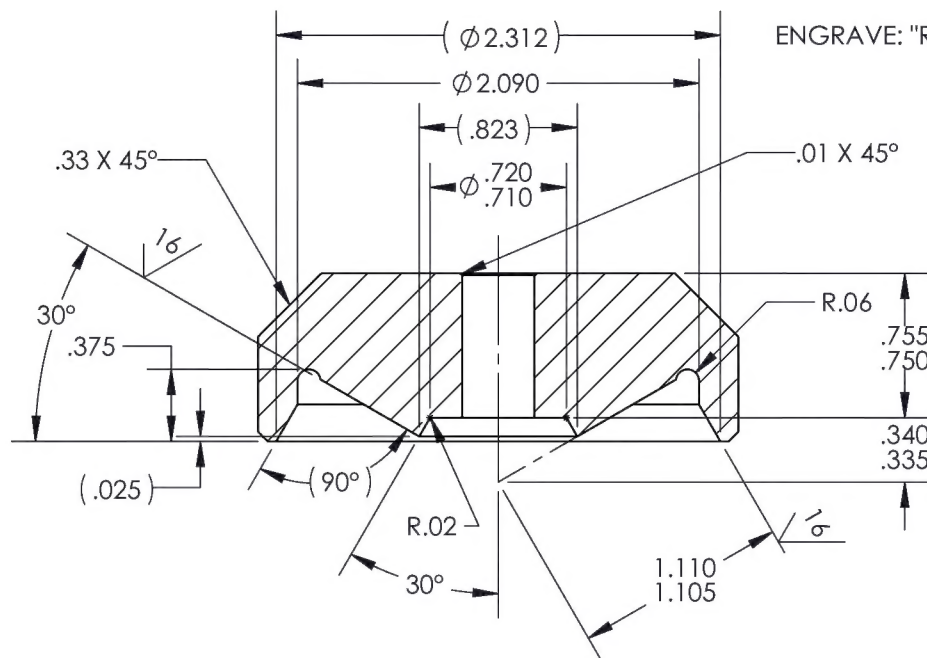
SECTION C-C



(-9)
RETAINER

RED BARN MACHINE			
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS			
DWG NO. RB T101577-1-9			REV
MAT'L ALUM. BRONZE		DRAWN BY: SMITH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .010 FRACTIONS ± 1/32		HEAT TREAT	
.XX ± .03 ANGLES ± .5°		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:1	DATE 8/26/2013	SHEET 5 OF 10	

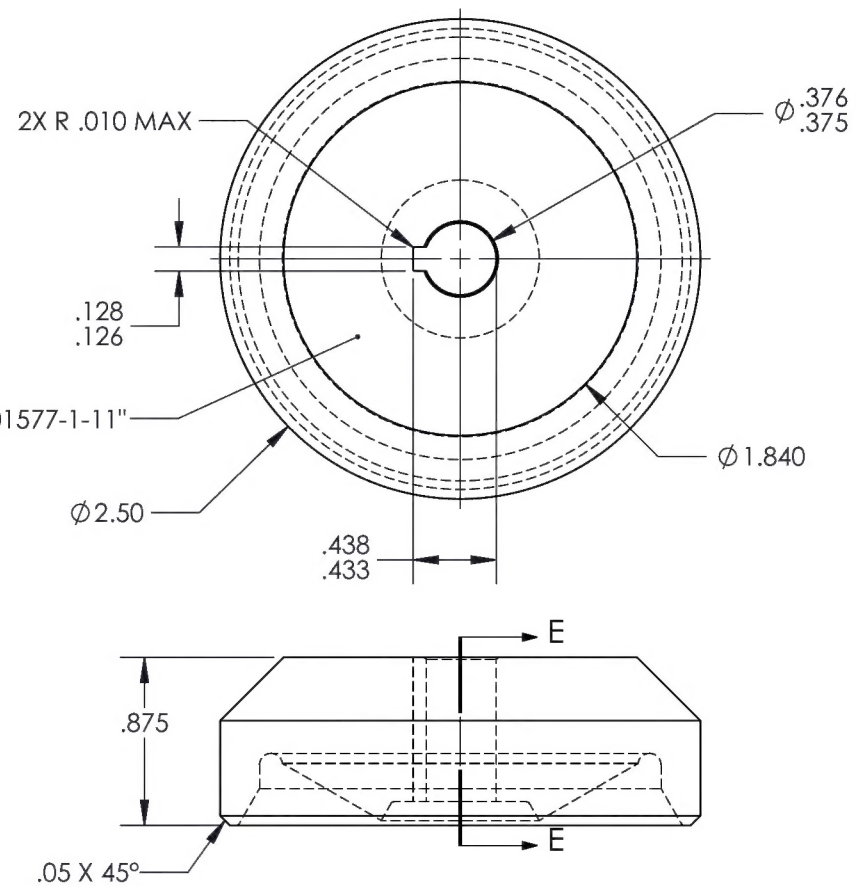
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED




SECTION E-E

-11

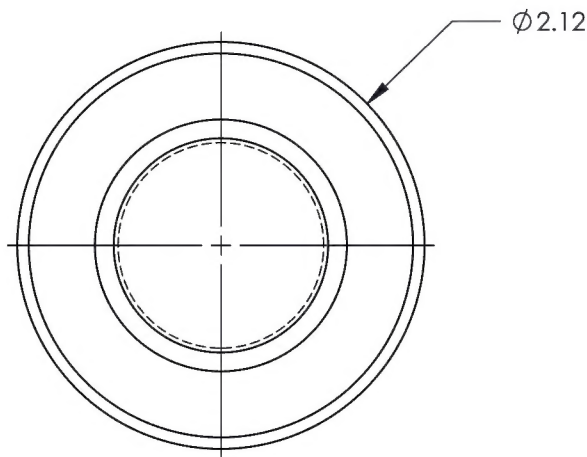
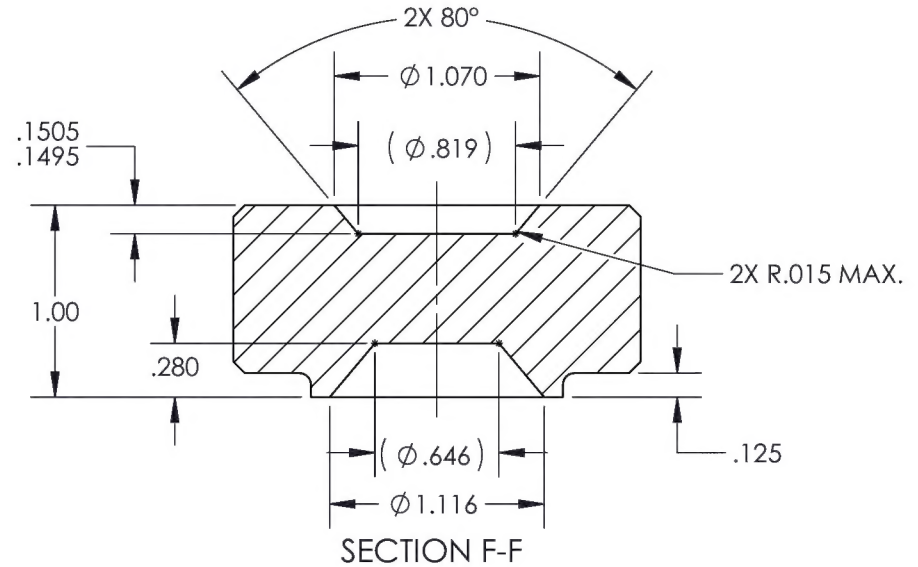
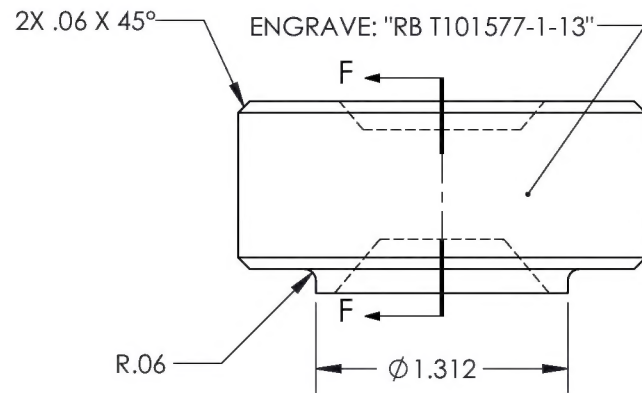
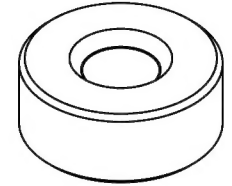
HOUSING



		<h1>RED BARN MACHINE</h1>	
<h2>TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS</h2>			
DWG NO.		RB T101577-1-11	
		REV	
MAT'L 01		DRAWN BY: SMITH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weill</i>	
$.XXX \pm .010$ $.XX \pm .03$ $.X \pm .1$		REAT RC 58-62 TREAT FINISH BLACK OXIDE	
1. BREAK ALL SHARP EDGES .015 x .45" OR .015R		SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE 1:1		DATE 8/26/2013	
		SHEET 6 OF 10	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

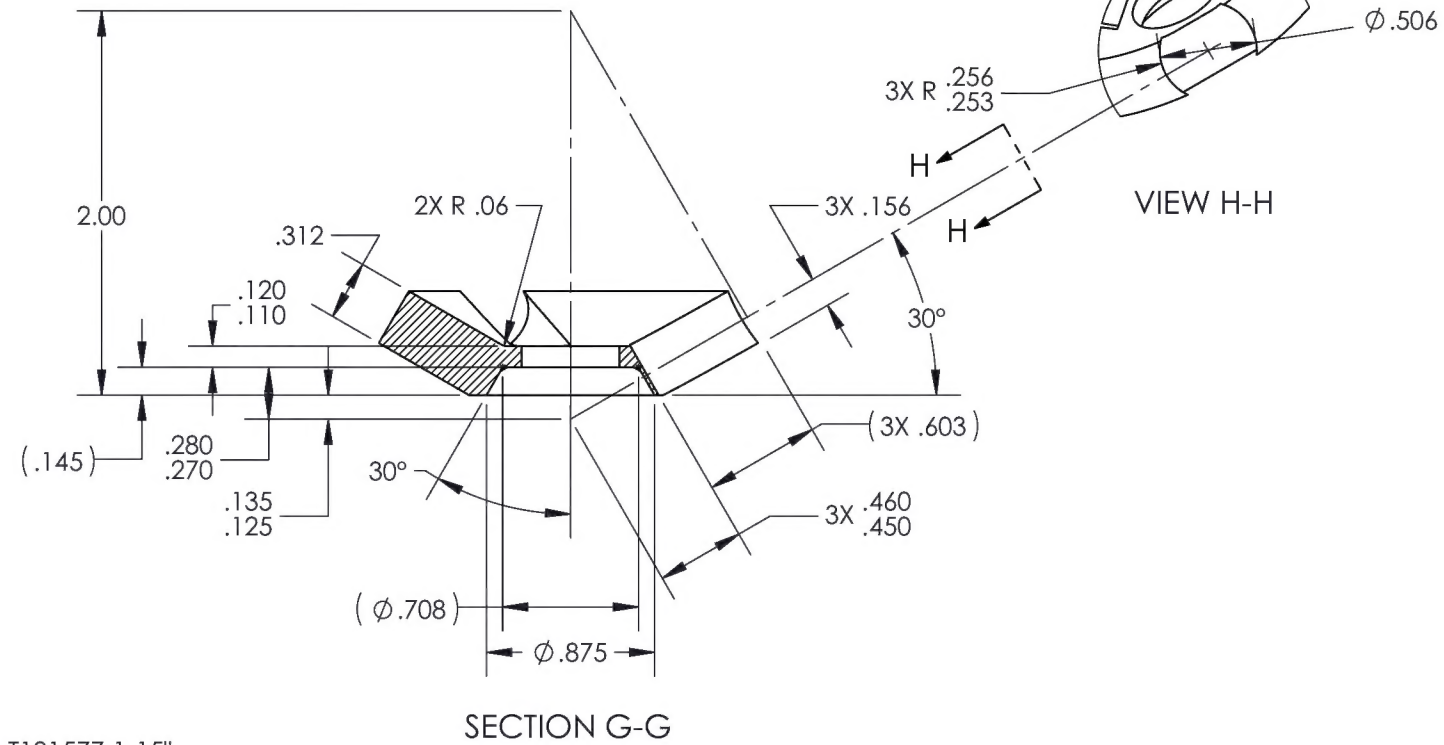
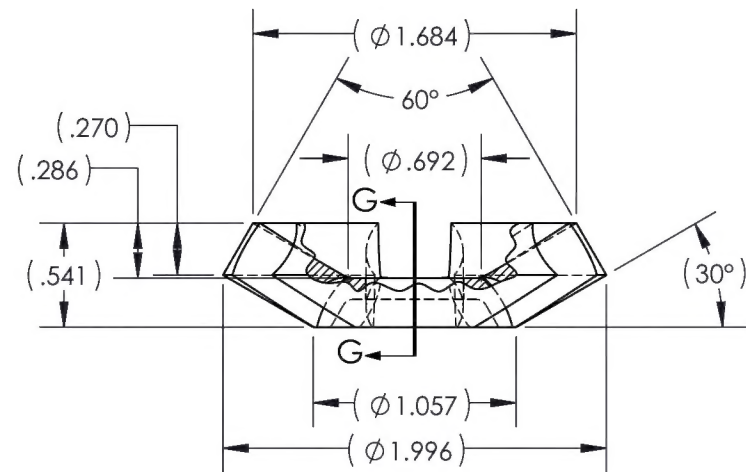
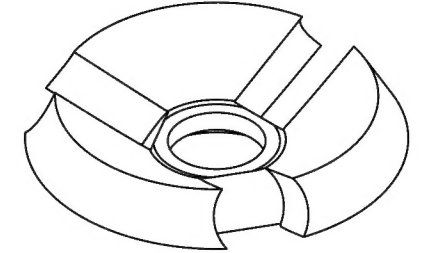
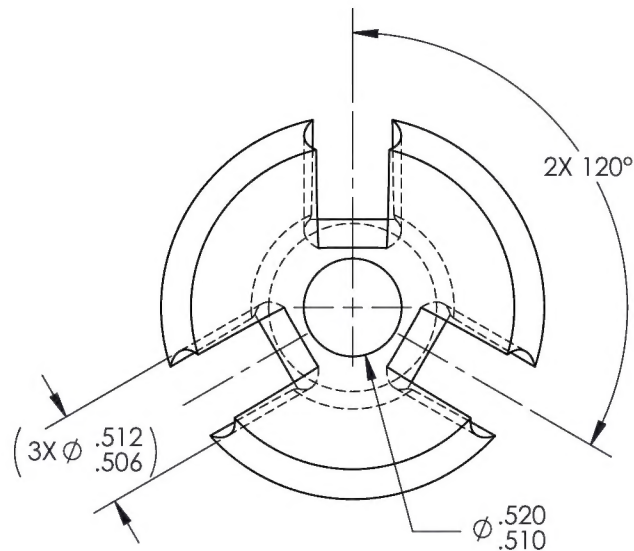


(-13)
BACK STOP

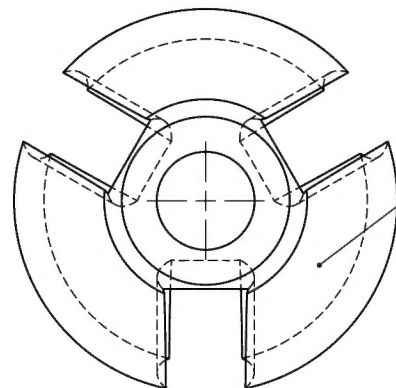
RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-13	
MAT'L 4140 Q&T	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT
.XX ± .03	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 7 OF 10	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



VIEW H-H



ENGRAVE: "RB T101577-1-15"

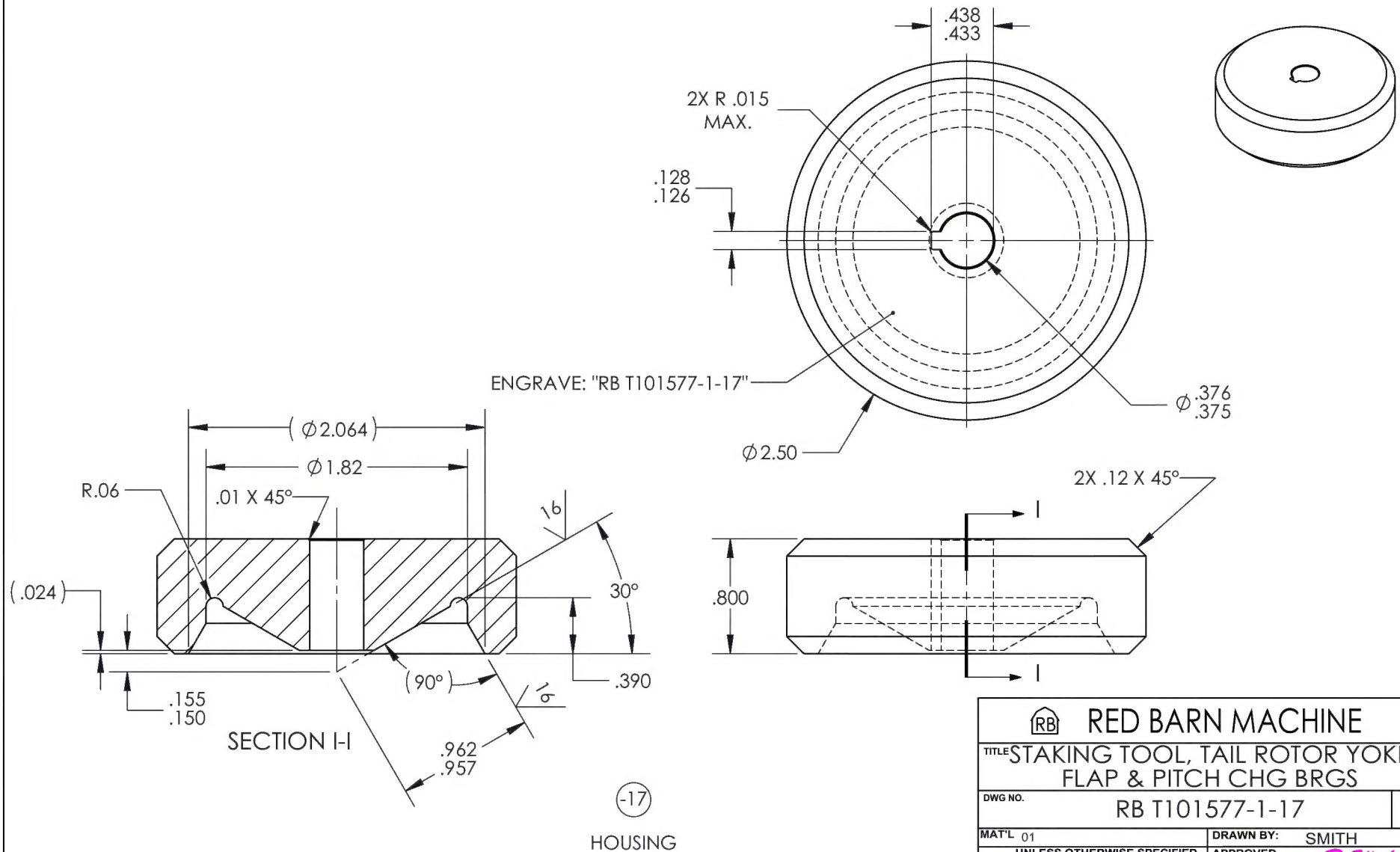
(-15)

RETAINER

RED BARN MACHINE			
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS			
DWG NO. RB T101577-1-15			REV
MAT'L ALUM. BRONZE		DRAWN BY: SMITH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .010 FRACTIONS ± 1/32		HEAT TREAT	
.XX ± .03 ANGLES ± .5°		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:1	DATE 8/26/2013	SHEET 8 OF 10	

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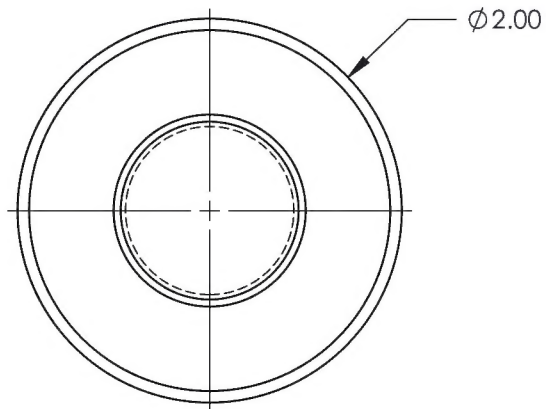
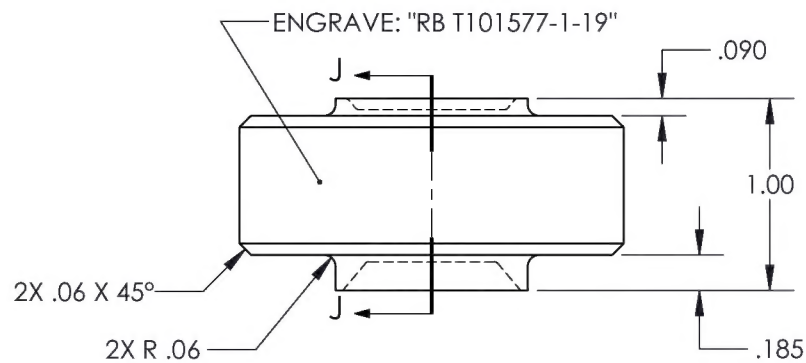
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



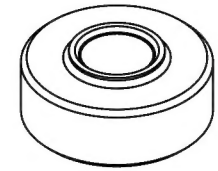
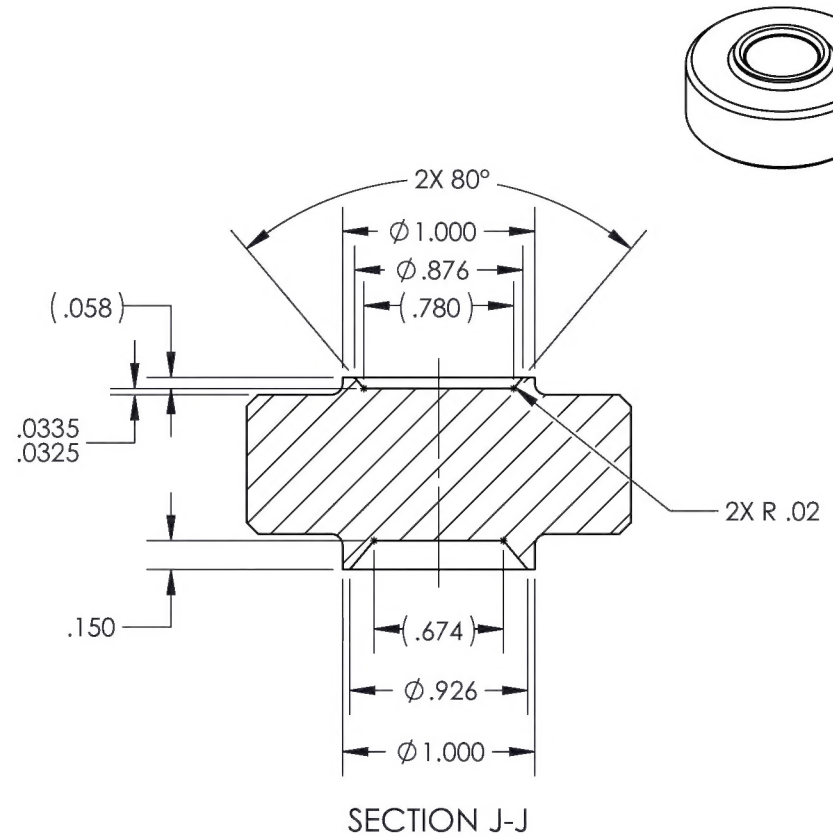
RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-17	REV
MAT'L 01	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT RC 58-62
.XX ± .03	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 9 OF 10	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



-19
BACK STOP



RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-19	
MAT'L 4140 Q&T	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013 SHEET 10 OF 10